

Work Order ID 145152

Tuesday, May 03, 2016 2:01:26 PM

145152

Page 1

Item ID: D5296-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: 2" O/C Buckle

Stop ***NS2***

Start Date: 5/6/2016 Start Qty: 32.00

32

Cust Item ID:

Required Date: 5/18/2016 Req'd Qty: 32.00

32

Customer:

Reference:

Approvals: Process Plan: MLJ Date: MAY 03 2016

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5296	B								

100

0.00

100

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 32473

Possible Supplier: CTS
Description: 2" O/C Buckle
Supplier P/N: 80944

C OF C is required

32

MAY 25 2016

DAS
13
9-89

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

2x 2016-05-26

DQA:

Date:

16-06-23



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

16/06/02

Work Order update only ☐

Work Order: <u>145152</u> Part No. <u>D5296-3</u> NCR No. <u>16-5814</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☒ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐							
Date: <u>16/5/26</u>		Step #: <u>100</u>		QTY Effective: <u>32</u>			MRB (QS1042) Approval DAS 12 16/5/26				
Description Work Order Deviation				Disposition				Completed By DAS 12 16/5/26			
Drawing Dims are wrong for -3. B: 6.5 should be 5.5 C: 1.45 " " 1.60 <i>DL</i>				Acceptable. Dwg is incorrect. ECN 16-548				Lead hand / Supervisor Approval Verification MAY 26 2016 DAS 38			
Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☒ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☒ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐				OTHER:			

Work Order ID 145152

Tuesday, May 03, 2016 2:01:26 PM

145152

Page 2

Item ID: D5296-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: 2" O/C Buckle

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									DAS
QC	Memo	0.00				(32)			38
Quality Control									MAY 26 2016
130	Identify as per dwg & Stock Location: <u>ST/15</u>	0.00							
130									DAS
Packaging	Memo	0.00				32			13
Packaging									9-89
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									MAY 27 2016
						MLJ			2m 16/05/27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

Picklist Print

Tuesday, May 03, 2016 2:01:30 PM

Page 1

Work Order ID: 145152

145152

Parent Item: D5296-3

D5296-3

Parent Item Name: 2" O/C Buckle

Start Date: 5/6/2016

Required Date: 5/18/2016

Start Qty: 32.00

Required Qty: 32.00

Comments: IPP REV:A 15.09.29 NEW ISSUE DD VERF:JLM IPP
REV:B 16.03.28 AS PER DWG REV.B DD VERF:JLM

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

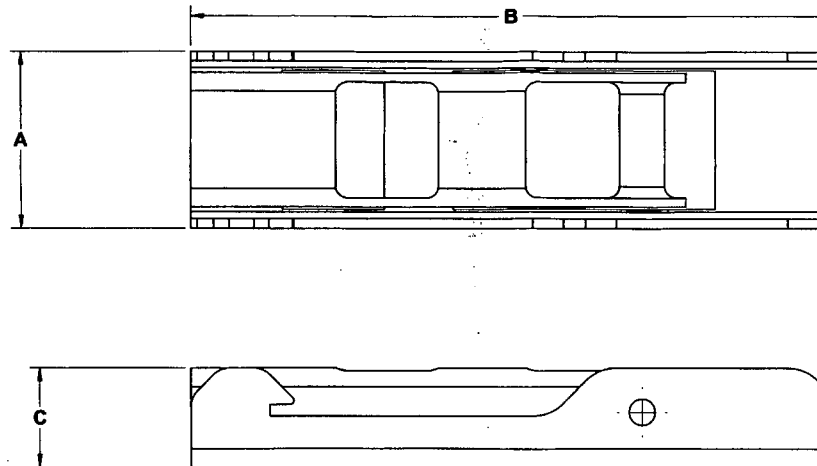
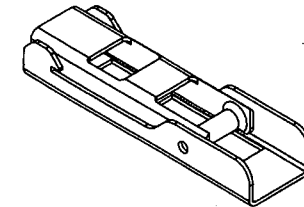
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

SPECIFICATION CONTROL DRAWING



D5296-X O/C BUCKLE

STOP COPY
RETURN TO
ENGINEERING
FOR CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

145152 MLJ
16-05-03

DART P/N	DESCRIPTION	VENDOR	VENDOR P/N	A	B	C	MATERIAL	WEIGHT	BREAKING STRENGTH
D5296-1	1" O/C BUCKLE	C.T.S.	81130	1.54	5.50	0.85	STEEL	0.53 LBS	3000 LBS
D5296-3	2" O/C BUCKLE	C.T.S.	80944	2.36	6.5	1.65	STEEL	0.73 LBS	4400 LBS

1.00

5.5

RELEASED
2015-09-08
an 16-026

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
- 7) WEIGHT: SEE TABLE

APPROVED

A	NEW ISSUE	DB	15.09.01
REV	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D5296	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	O/C BUCKLE	NTS
DATE	15.09.01	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32473

Purchase Order Date 5/25/2016

PO Print Date 5/25/2016

Page Number 1 of 2

Order From :

VC-ROY001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

RBC ROYAL BANK - VISA
PAYMENT CENTRE, PO BOX 4016, STAT. A
TORONTO, ON M5W 1X6
CA

E-MAILED

MAY 25 2016

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

Buyer

Customer POID

Customer Tax #.

Terms

Currency

FOB

Chantal Lavoie

10127-2607

COD

CAD

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
80944	AS PER DWG D5296 REV. B B145152	2" O/C Buckle	5/27/2016 Yes 5/27/2016	FN	32.00 Each	\$6.62	\$211.84
Line Total:							\$211.84
2	81130	1" O/C Buckle	5/27/2016 Yes 5/27/2016	FN	48.00 Each	\$6.62	\$317.52
Line Total:							\$317.52
3	18460	1" Snap Hook	5/27/2016 Yes 5/27/2016	FN	48.00 Each	\$2.03	\$97.20
Line Total:							\$97.20

PO Instructions: CTS CARGO TIE-DOWN

Note:

5/25/2016

CTS



Cargo Tie-Down Specialty Inc.

- FLATBED • MARINE
- INTERIOR VAN • RAIL
- AUTO TIE-DOWN

160 Milner Avenue, Toronto, ON. M1S 3R3
Toll Free 1-888-412-7144 Tel: 416-412-7144 Fax: 416-412-7145
Website: www.ctscargotiedown.com E-Mail: sales@ctscargotiedown.com

GRIZZLYWEB

PACKING SLIP

ACCOUNT #	ORDER DATE	PACKING SLIP NO
COD	5/25/2016	186127

BILL TO

DART AEROSPACE
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

SHIP TO

DART AEROSPACE
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7



613 632 9577

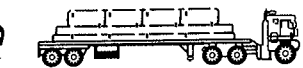


PICKUP TIME:

PO NO.	ORDER BY	SHIP DATE	SHIP VIA	FOB	TERMS	REP		
PO32473	CHANTEL ...	5/25/2016	PUR#7684382	TORONTO	CREDIT CARD	HA		
TOTAL PKG	ITEM NUMBER	DESCRIPTION	QUANTITY ORDERED	QUANTITY SHIPPED	QTY B/O	UNIT	UNIT WT (LBS)	BIN #
1	80944	2" OVERCENTER BUCKLE B/S: 4,400LBS	32	32	0	EA	0.75	C9-4
1	81130	1" OVERCENTER BUCKLE, B/S: 3,000 LBS	48	48	0	EA	0.53	B9-9
1	18460	1" SNAP HOOK, B/S: 3,000LBS, Y/Z	48	48	0	EA	0.21	B7-2
1	18420	2" TWISTED SNAP HOOK, B/S: 11,000LBS, Y/Z	64	64	0	EA	0.59	B3-6
=====								
PRODUCT CERTIFICATE REQUIRED								
SHIP VIA PUROLATOR NEXT DAY #7684382								
USE CREDIT CARD ENDING#4712								
HST (ON) on sales								
JP 16-05-26								
BAG/REEL	BUNDLE	CARTON	SKID	DIMENSIONS	TOTAL WEIGHT (LBS)	RECEIVED BY	RECEIVED DATE	
		4			109			

Claims for shortages or defects must be made within 5 days after their arrival. After such time, the Buyers shall not be entitled to make any claim on account of shortages, defects or other cause.

CTS



- FLATBED • MARINE
- INTERIOR VAN • RAIL
- AUTO TIE-DOWN • CARGO NET

Cargo Tie-Down Specialty Inc.

160 Milner Avenue, Toronto, ON. M1S 3R3 CANADA

Tel: 416-412-7144 / 1-888-412-7144 (CAN/USA)

Fax: 416-412-7145

Website: www.ctscargotiedown.com

E-Mail: sales@ctscargotiedown.com



WHATEVER YOU NEED, GET IT WITH SPEED
TOP QUALITY, NO COMPROMISE
Outlasts ordinary straps, get "GRIZZLYWEB" straps!

INVOICE

Invoice Date Invoice #

5/25/2016

89476

Bill To

DART AEROSPACE
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

Ship To

DART AEROSPACE
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

Customer Account No.	COD	Phone No.	613 632 9577	Fax No.	Ordered By	CHANTEL LA...		
Packing Slip No.	P.O.No.	Terms	Rep	Ship Date	Ship Via			
186127	PO32473	CREDIT CARD	HA	5/25/2016	PUR#7684382			
Item	Description	QUANTITY			Unit	Price	Amount	
		Ordered	Shipped	B/O				
80944	2" OVERCENTER BUCKLE B/S: 4,400LBS	32	32	0	EA	6.62	211.84	
81130	1" OVERCENTER BUCKLE, B/S: 3,000 LBS	48	48	0	EA	6.62	317.76	
18460	1" SNAP HOOK, B/S:3,000LBS, Y/Z	48	48	0	EA	2.03	97.44	
18420	2" TWISTED SNAP HOOK, B/S:11,000LBS, Y/Z	64	64	0	EA	3.78	241.92	
=====								
PRODUCT CERTIFICATE REQUIRED								
SHIP VIA PUROLATOR NEXT DAY #7684382								
****USE CREDIT CARD ENDING#4712****								
SHIP DATE: MAY.25.2016								
4 CARTONS = 109 LBS								
TRACKING# 330742839526								
PAID ☐ DEBIT _____ CASH _____ VISA _____ AMEX _____ MASTER _____ CHEQUE _____ E-PAYMENT _____								
PAYMENT TERMS - For Customers with approved credit, payment terms are net 30 days from date of shipment. VISA, MASTERCARD and AMERICAN EXPRESS card orders are accepted. RETURNS - If for any reason, you are dissatisfied with a product you receive from CTS, you may at any time within 5 days from your receipt of shipment return such goods for a full credit, exchange or refund. The return of custom and made-to order products is subject to the prior approval and restocking charges. Returned products must be shipped prepaid.						Subtotal		CAD 868.96
						HST/GST		CAD 112.96
						Total		CAD 981.92
						Payments/Credit		CAD 0.00
						Balance Due		CAD 981.92
HST #896781127		Due Date	5/25/2016					

Thank you for your order. We appreciate your business!



160 Milner Avenue, Toronto, ON M1S 3R3, CANADA
Tel: 416-412-7144 / 1-888-412-7144 Fax: 416-412-7145
Email: sales@ctscargotiedown.com
Website: www.ctscargotiedown.com

Customer Name	Purchase Order Number	Packing slip No.	Purchase Date (MM-DD-YYYY)
DART AEROSPACE	32473	186127	05-25-2016

Certificate of Compliance – Hardware/Webbing

Qty.	Item No.	Description	WORKING LOAD LIMIT (LBS)	BREAKING STRENGTH (LBS)	Country of Origin
32	80944	2" OVERCENTER BUCKLE	1,466	4,400	CN
48	81130	1" OVERCENTER BUCKLE	1,000	3,000	CN
48	18460	1" SNAP HOOK	1,000	3,000	CN
64	18420	2" TWISTED SNAP HOOK	3,600	11,000	CN

I hereby certify that the goods listed hereon have been inspected and/or tested, as applicable, and conform to all specifications and requirements detailed in the contract or purchase order and relevant quality clauses. This report is applicable only to the sample or samples tested. Rework of this product may alter these results.

Signed by: *MFong*

Design Factor

The design factor for tie downs shall be a minimum of 3.

Proof Test

Has been test to a minimum of one and one half (1.5) times the working load limit (WLL).